

Work Order ID 125662

Friday, October 17, 2014 3:23:08 PM

125662

Page 1

Item ID: D350-636-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/17/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *14-10-17* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Draw Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4168-041	B								
100	Document Control	0.00							DAS 38 9-89
100	DOCUMENT CONTROL								
DC	Memo								
Doc.Control -USB or Paperwork	record fwd angle								

SH

JK

DAS
06
9-89

NOV 18 2014

14-11-17

Photocopy blue file and type labels per PPP D350-636-015 CHG 005

B125662L+1

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Item ID: D350-636-015

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center ID
110Operation
DescriptionSet Up/
Down Hours
0.00Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp***110***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168, detail A

6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.

7- Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side)

8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left

Ref. No. 23.

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Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

from bending as per QSI 004

A/R Aluminum Rod batch: *M129285*

9- Grind welds flush as per Dwg D4168

78614-10-23

120 QC10- Inspect visual per QSI004- ground welds 0.00

120

QC Memo 0.00

Quality Control

D 14-10-27

DAS
9
9-89

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

D 14-10-27

DAS
9
9-89

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Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
140	Chemical Conversion Coat per QSI005 4.1	0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

①

14-10-27

[Signature]

DAS
18
8-00

1

0

14-10-28

Work Order ID 125662

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Item ID: D350-636-015

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Stop ***NS2***

Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/17/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center ID
160Operation
DescriptionSet Up/
Run Hours
0.00

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp***160***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes using hole saw of Detail C and ground handling section AL-AL to 0.625" (total of 8 holes per side) as per dwg D4168.

2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168.

3- Open float hole to 0.500" using uni-bit (4 per side) section AJ-AJ

Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG

4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes section AJ-AJ per dwg D4168 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015, let cure for 12hrs.

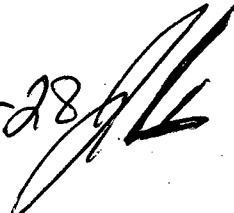
A/R Sikaflex-291 batch: 130227
exp. date: 15-2-5

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1 & QSI004

(welding instructions on sheet 8)

A/R Aluminum Rod batch: 7129286

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

14-10-28 

7 BE 14-10-30

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Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section AL-AL

12- C'bore section CG-CG. ADJUST TOOLING AS REQUIRED.
VERF BY: _____

13- Deburr holes, ensure tube is free of all scratches before sending to paint.

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE *****
*****REF TO W/O BATCH: NIA*****

170

QC10- Inspect visual per QS1004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

DAS
9
9-89

14-10-14-11-05

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
210	QC14- Inspect Spray Paint	0.00								
210										
QC	Memo	0.00								
Quality Control	Inspect for foreign object per QSI 024									
230		0.00								
230	HandFinishing									
HandFinish	Memo	0.00								
Hand Finishing	1- Install inserts as per Dwg D4168									
	2-Inspect for Foreign Objects									
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168									
	SIKA FLEX 241									
	BATCH: <u>N1130227</u>									
	EXP DATE: <u>15/06</u>									
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube									
	A/R 55-o'ring lube batch: <u>N1129305</u> RTU 598 B4K 11125792 exp 15/06									
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>N1127900</u>									

DAS
15
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Required Date: 10/17/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/

Operation

Set Up/

Tool ID

Tool #

Plan

Accept

Reject

Reject

Insp.

Work Center ID

Description

Run Hours

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

NOV 12 2014

250

250

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

If making a D350-636-215

pick kit will only requires:

1 X AN3C37A

1 X AN3C34A

1 X AN3C42A

2 X D3493-1

DAS
27
0.00

DAS
27
0.00
14/11/18

260

260

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

*****ensure antiseize is on AN8C21A bolts*****

DAS
38
9-89

14-11-17

Work Order ID 125662***125662***

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Item ID: D350-636-015

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Revision ID:

Stop ***NS2***

Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/17/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-015								
	Location: <u>16 071</u>								
	PPP rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

NOV 18 2014

DAS
06
9-89DAS
46
9-89

14/11/19

11/11/19

Picklist Print

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Work Order ID: 125662

125662

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per
NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-
542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C34A		Purchased	No			230	Each	17.0000	1	1			
AN3C34A									**				
BOLT													

10/11/11

Location	Loc Qty	Loc Code
ST352	17	
m127044	17	
AN3C36A		
Purchased	No	
230	Each	214.0000
4		4
AN3C36A		**
Bolt		

10/11/11

Location	Loc Qty	Loc Code
FG	25	
101261	4	
122204	11	
124827	10	
ST347	189	
m127769	1	
m128398	13	
m129907	175	

10/11/11

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates. DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

D3492-1

Manufactured No

230 Each

Start Qty: 1.00
177.0000 8 8

Required Qty: 1.00

D3492-1

Plug

**

all value

Location

Loc Qty

Loc Code

FP001

177

111578

2

114879

7

119646

2

120519

2

122460

44

124026

120

✓ 8

D3492-3

Manufactured No

230 Each

214.0000 8 8

D3492-3

Plug

**

all value

Location

Loc Qty

Loc Code

FP001

214

104853

24

107331

1

112739

1

115807

6

118977

2

123464

100

124027

80

✓ 8

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

D3873-1 Manufactured No 230 Each 159.0000 7 7 Start Qty: 1.00 Required Qty: 1.00
D3873-1 ** *ll 10/17/14*
Bushing

Location	Loc Qty	Loc Code
ST063	159	
104858	5	13121363
105611	8	
109110	1	
121363	17	
122917	68	
124192	60	

D4154-041 Manufactured No 230 Each 4.0000 1 1 Start Qty: 1.00 Required Qty: 1.00
D4154-041 ** *ll 10/17/14*
Wearplate Assembly

Location	Loc Qty	Loc Code
FP002	4	
106716	1	
113649	1	
121481	2	

D4170-1 Manufactured No 230 Each 174.0000 4 4 Start Qty: 1.00 Required Qty: 1.00
D4170-1 ** *BE1410-29*
Bushing

Location	Loc Qty	Loc Code
LG	41	
123940	41	
LG001	133	
107896	89	
119639	44	

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D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

D4171-1 Manufactured No

230 Each

Start Qty: 1.00
11.0000 1 1

Required Qty: 1.00

D4171-1

Bushing

**

all include

Location	Loc Qty	Loc Code
----------	---------	----------

ST096	11	
-------	----	--

109144	1	
--------	---	--

125038	10	
--------	----	--

MS21043-3 Purchased No

230 Each

142.0000 5 5

**

all include

MS21043-3

Nut

Location	Loc Qty	Loc Code
----------	---------	----------

FG	80	
----	----	--

103691	80	
--------	----	--

GA	20	
----	----	--

m130186	20	
---------	----	--

ST306	42	
-------	----	--

m128398	16	
---------	----	--

m129472	9	
---------	---	--

m129521	17	
---------	----	--

NAS1149C0363R Purchased No

230 Each

484.0000 9 9

**

all include

NAS1149C0363R

Washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST278	484	
-------	-----	--

114742	455	
--------	-----	--

122441	7	
--------	---	--

m128591	22	
---------	----	--

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D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates. DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

NAS1515H3L Purchased No 230 Each 265.0000 4 4

Start Qty: 1.00

Required Qty: 1.00

***NAS1515H3I ***

Washer

**

Handwritten signature

Location	Loc Qty	Loc Code
FG	40	
102472	40	
ST273	225	
m127831	136	
m128976	89	

NAS1611-010 Purchased No 230 Each 319.0000 8 8

NAS1611-010

O-RING

**

Handwritten signature

Location	Loc Qty	Loc Code
FP001	319	
m126988	3	
m127813	4	
m128375	10	
m129198	44	
m129405	82	
m129523	176	

NAS1611-013 Purchased No 230 Each 392.0000 8 8

NAS1611-013

O-RING

**

Handwritten signature

Location	Loc Qty	Loc Code
FP001	392	
130581	200	
m128375	72	
m129430	20	
m130358	100	

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Start Date: 10/17/2014

Required Date: 10/17/2014

AN3C37A

Purchased

No

250

Each

Start Qty: 1.00
423.0000 1 1

Required Qty: 1.00

AN3C37A

BOLT

**

DAS
27
9-89
14/10/17

Location

Loc Qty

Loc Code

ST347

216

M127823

7

M129650

200

M129687

9

ST353

7

M127823

7

ST514

200

M128773

200

AN3C42A

Purchased

No

250

Each

50.0000 1 1

AN3C42A

Bolt

**

DAS
27
9-89
14/10/17

Location

Loc Qty

Loc Code

FG

5

121103

5

ST347

30

m130485

30

ST353

15

m127300

1

m128830

8

m130460

6

DAS
06
9-89

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Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

NAS1149D0863J

Purchased

No

250

Each

781.0000

Start Qty: 1.00

2

2

**

Required Qty: 1.00

DAS

21

0.00

NH/17

NAS1149D0863.J

Washer

Location

Loc Qty

Loc Code

ST276

581

118078

2

125268

579

ST2776

200

125635

200

D2744

Manufactured

No

110

Each

37.0000

1

1

**

BEH-10-23

D2744

Cap

Location

Loc Qty

Loc Code

LG001

37

113128

36

115440

1

D2600-3-BENT-LH

Manufactured

No

110

Each

6.0000

1

1

**

D2600-3-BENT-LH

Extrusion Bent LH

Location

Loc Qty

Loc Code

LG

6

124662

6

D2743

Manufactured

No

160

Each

234.0000

8

8

**

14-10-22
BEH-10-22

D2743

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

170

124423

170

LG001

64

109799

1

120481

63

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Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

D2739

Manufactured No

160

Each

9.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

D2739

350 1 Beam

**

Location

Loc Qty

Loc Code

LG

6

124522

6

LG002

3

117245

2

117803

1

D3490-3

Manufactured No

160

Each

89.0000

4

4

D3490-3

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG

89

22751

8

124024

81

D3490-1

Manufactured No

160

Each

116.0000

4

4

D3490-1

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG

115

122457

35

124025

80

LG001

1

112737

1

① 14-10-28

BE 14-10-29

BE 14-10-29

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Page 9

Work Order ID: 125662

125662

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

ALS4-1032-225 AELS8-1032-225 Purchased No

230 Each

Start Qty: 1.00
2,077.000 4 4

Required Qty: 1.00

ALS4-1032-225

*ALS4-1032-225

Rivnut

**

all rubber

Location	Loc Qty	Loc Code
FG	30	
M127028	30	
FP001	113	
M128649	113	
ST267	1934	
M127028	10	
M127092	26	
M128179	168	
M130565	730	<i>✓</i>
M130579	1000	

AN8C35A Purchased No

230 Each

65.0000 1 1

AN8C35A

Bolt

**

all rubber

Location	Loc Qty	Loc Code
FG	4	
I21275	4	
FP001	61	
m126293	29	
m127823	1	
m130114	31	<i>✓</i>

D3488-041 Manufactured No

230 Each

14.0000 1 1

D3488-041

Blade Fitting LH

**

all rubber

Location	Loc Qty	Loc Code
FP001	14	
I16834	2	
I22534	11	<i>✓</i>
88255	1	

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Page 10

Work Order ID: 125662

125662

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates. DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

AN6C44A Purchased No 230 Each 21.0000 4 4 Start Qty: 1.00 Required Qty: 1.00
AN6C44A ** *all wheels*
Bolt

Location	Loc Qty	Loc Code
FG	2	
103964	2	M130665
ST333	19	
m128319	2	
m128700	1	
m129199	16	

MS21083C8 Purchased No 230 Each 94.0000 1 1 Start Qty: 1.00 Required Qty: 1.00
MS21083C8 ** *all eddy*
Nut

Location	Loc Qty	Loc Code
ST302	94	
m127255	5	
m128119	2	
m128798	48	
m130358	39	

D3631-1 Manufactured No 230 Each 178.0000 8 8 Start Qty: 1.00 Required Qty: 1.00
D3631-1 ** *all 4/10/11*
Washer

Location	Loc Qty	Loc Code
FP001	178	
110258	16	B124353
119553	10	
123452	52	
124353	100	

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Page 11

Work Order ID: 125662

125662

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

NAS1149C0332R

Purchased

No

230

Each

Start Qty: 1.00
8,749.000 4 4

Required Qty: 1.00

NAS1149C0332R

WASHER

**

all whole

Location	Loc Qty	Loc Code
CA	83	
m129682	83	
ST278	8666	
122063	41	
125654	425	
m126319	51	
m127306	2065	
m127831	26	
m128591	75	
m129499	191	
<u>m130325</u>	4792	<i>xd</i>
m130466	1000	

D2745

Manufactured

No

230

Each

209.0000 8 8

D2745

Bushing

**

all whole

Location	Loc Qty	Loc Code
ST010	209	
107336	4	
113176	2	
117099	7	
119572	51	
122643	25	
<u>124375</u>	120	<i>xd</i>

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Page 12

Work Order ID: 125662

125662

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

NAS1149C0832R	Purchased	No	230	Each	252.0000	1	1	Start Qty: 1.00	Required Qty: 1.00
NAS1149C0832R								**	<i>all 14/10/10</i>
Washer									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST277	252	
m114915	102	
m125807	150	

AN3C6A	Purchased	No	230	Each	981.0000	4	4	**	<i>all 14/10/10</i>
AN3C6A									
Bolt									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	
122416	10	
ST513	971	
m125709	15	
m128769	956	

MS21043-6	Purchased	No	230	Each	124.0000	4	4	**	<i>all 14/10/10</i>
MS21043-6									
NUT									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693	20	
ST306	104	
m127255	6	
m127813	10	
m130325	88	

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Work Order ID: 125662

125662

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

D3493-1 Manufactured No 250 Each 125.0000 2 2

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Washer

**

DAS
27
9-89
M/11/12

Location Loc Qty Loc Code

FG 10

97201 10

ST046 115

109105 115

MS21083C8

Purchased No

250 Each

94.0000

2

2

MS21083C8

Nut

**

DAS
27
9-89
M/11/12

Location Loc Qty Loc Code

ST302 94

m127255 5

m128119 2

m128798 48

m130358 39

AN8C21A

Purchased No

250 Each

48.0000

2

2

AN8C21A

Bolt

**

DAS
27
9-89
M/11/12

Location Loc Qty Loc Code

FG 2

123966 2

ST332 46

m127061 2

m127823 3

m129888 41

DAS
96
9-89

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125662

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 10/17/2014

Required Date: 10/17/2014

D2741

Manufactured	No
--------------	----

250	Each
-----	------

39.0000	Start Qty: 1.00
	1

Required Qty: 1.00

D2741

Blade

DWG
27
9-69

14/11/17

DAS
66
9-69

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	9	
100664	5	
113640	1	
115522	3	B12407
ST538	30	1
118387	30	

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO. 125662 MLO

14-10-17

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2013-08-13
JMD

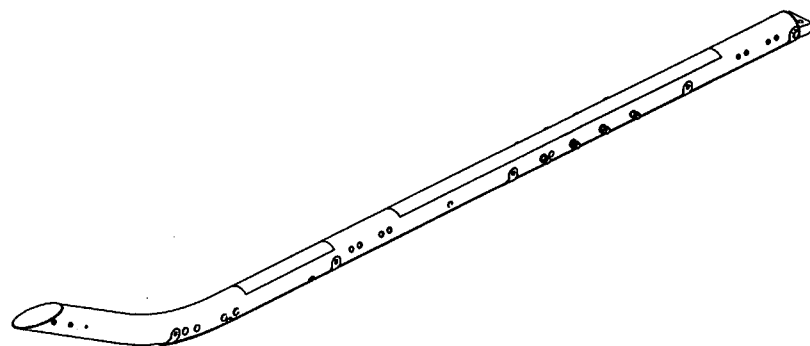
B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.
KENT, WA

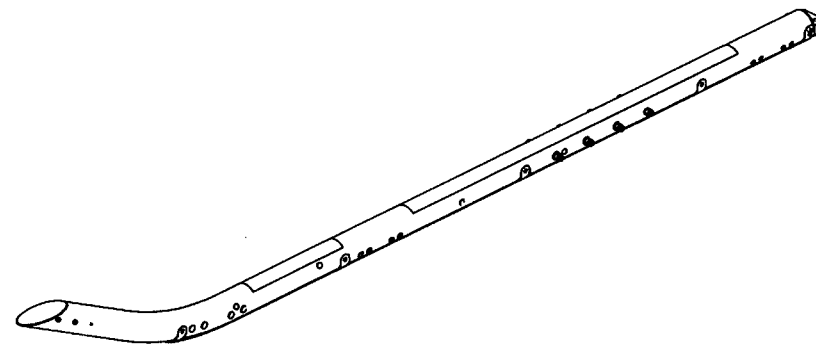
DRAWING NO. **D4168**
TITLE **350 SKIDTUBE ASSEMBLY**

REV. B
SHEET 1 OF 11
SCALE
NTS

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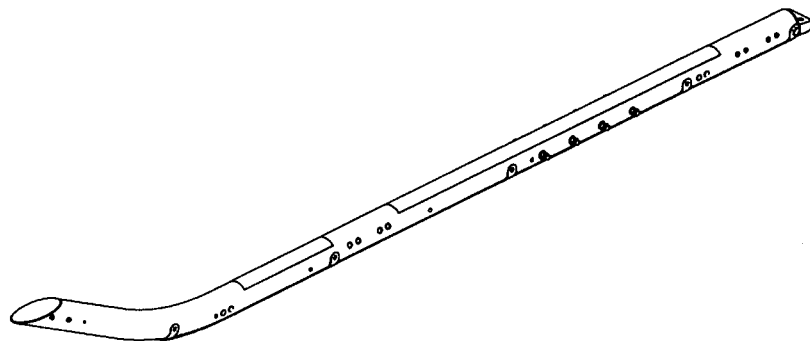
D4168-041 350 SKIDTUBE ASSEMBLY, LH



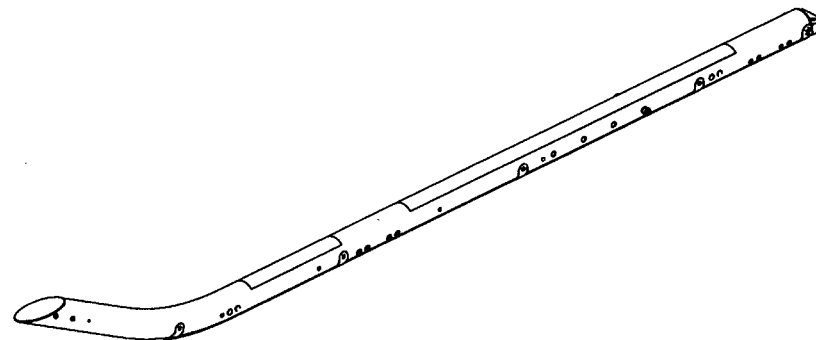
D4168-042 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13

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D4168-043 350 SKIDTUBE ASSEMBLY, LH

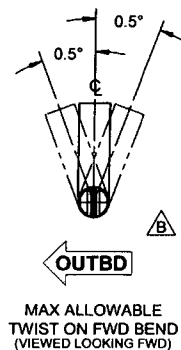
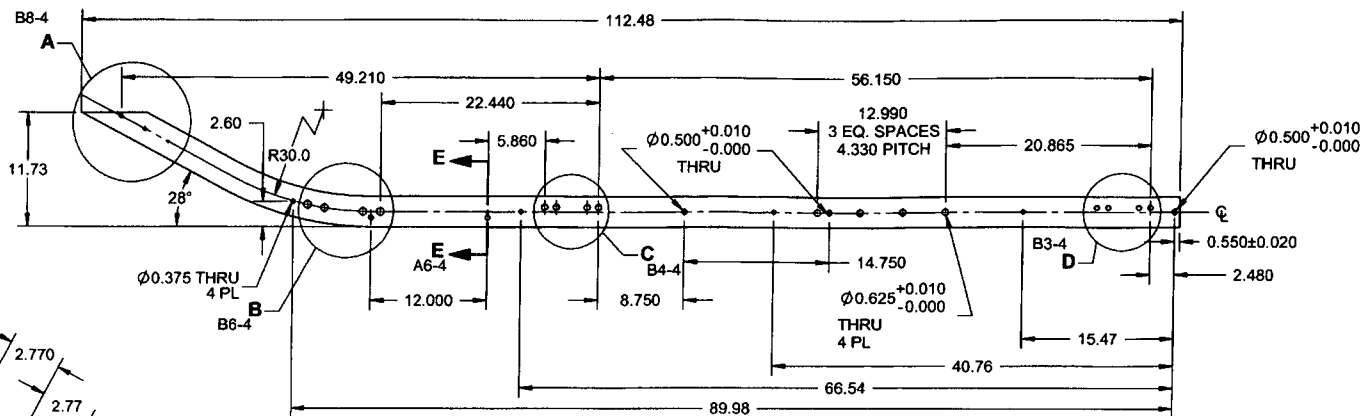


D4168-044 350 SKIDTUBE ASSEMBLY, RH

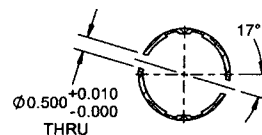
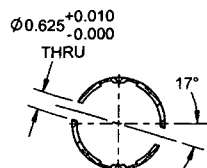
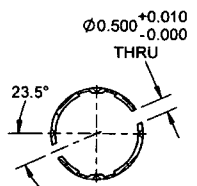
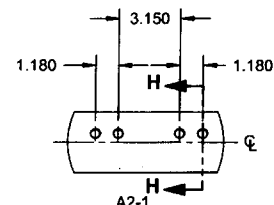
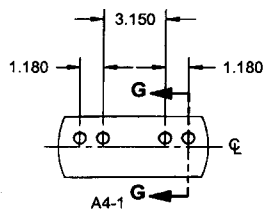
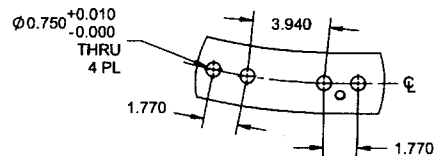
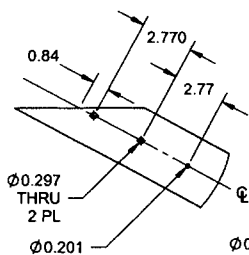
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MFG. APPR.	JP	D4168	SHEET 3 OF 11
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DE APPR.	JP	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4168-1 LH SKIDTUBE



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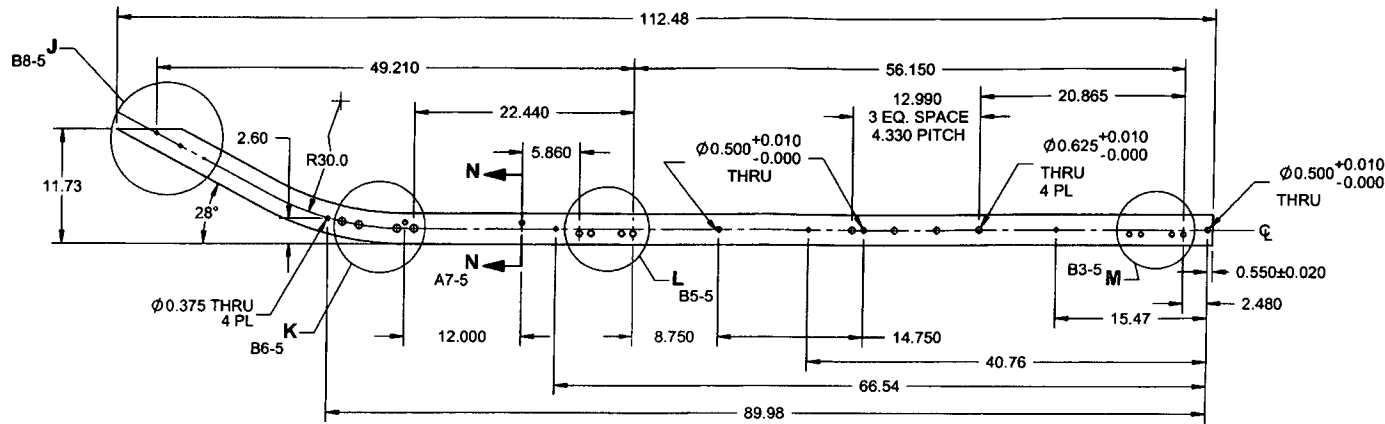
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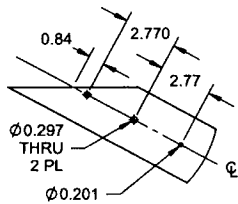
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350 SKIDTUBE ASSEMBLY
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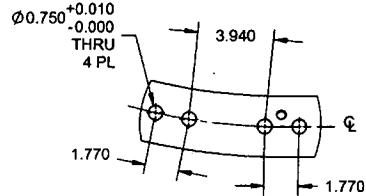
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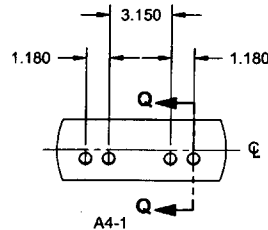
D4168-2 RH SKIDTUBE



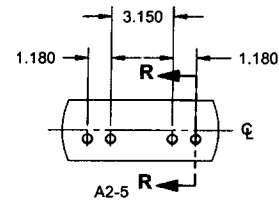
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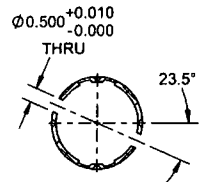
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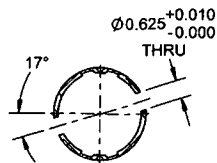
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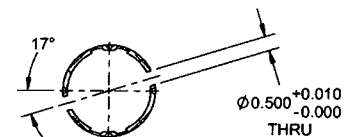
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SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL

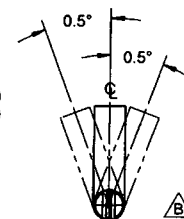
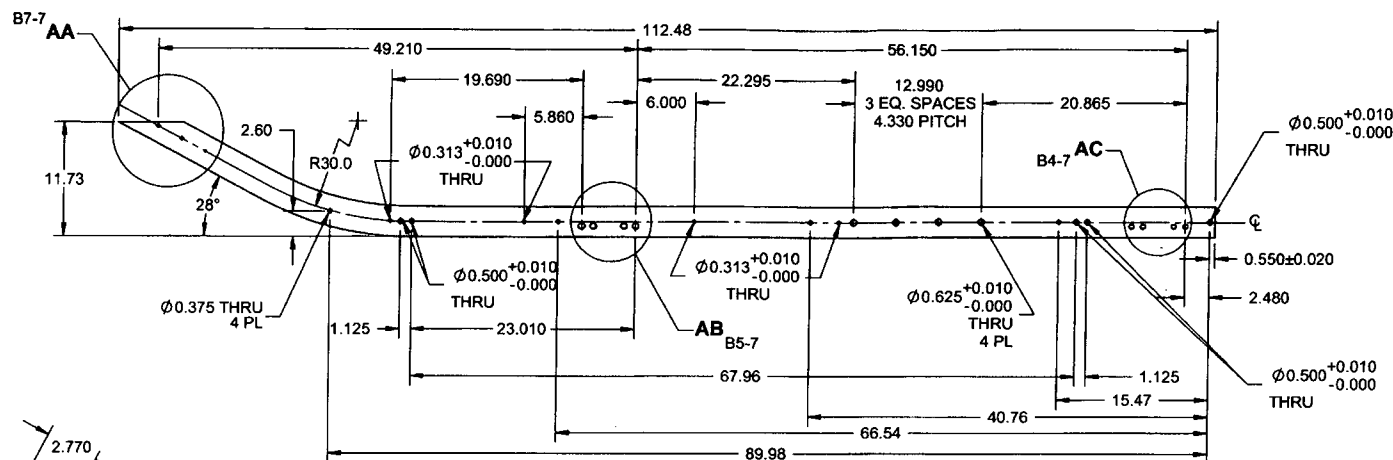


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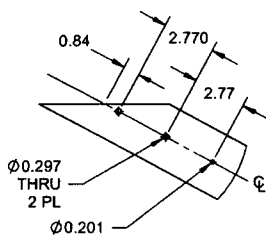
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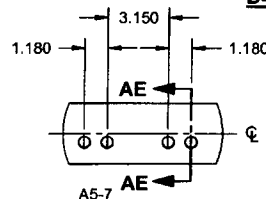


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

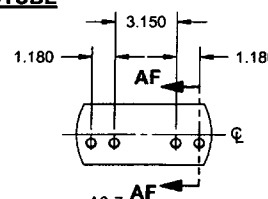
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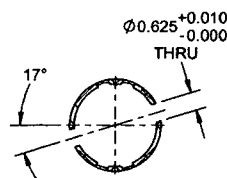
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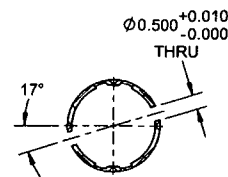
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SCALE 2X



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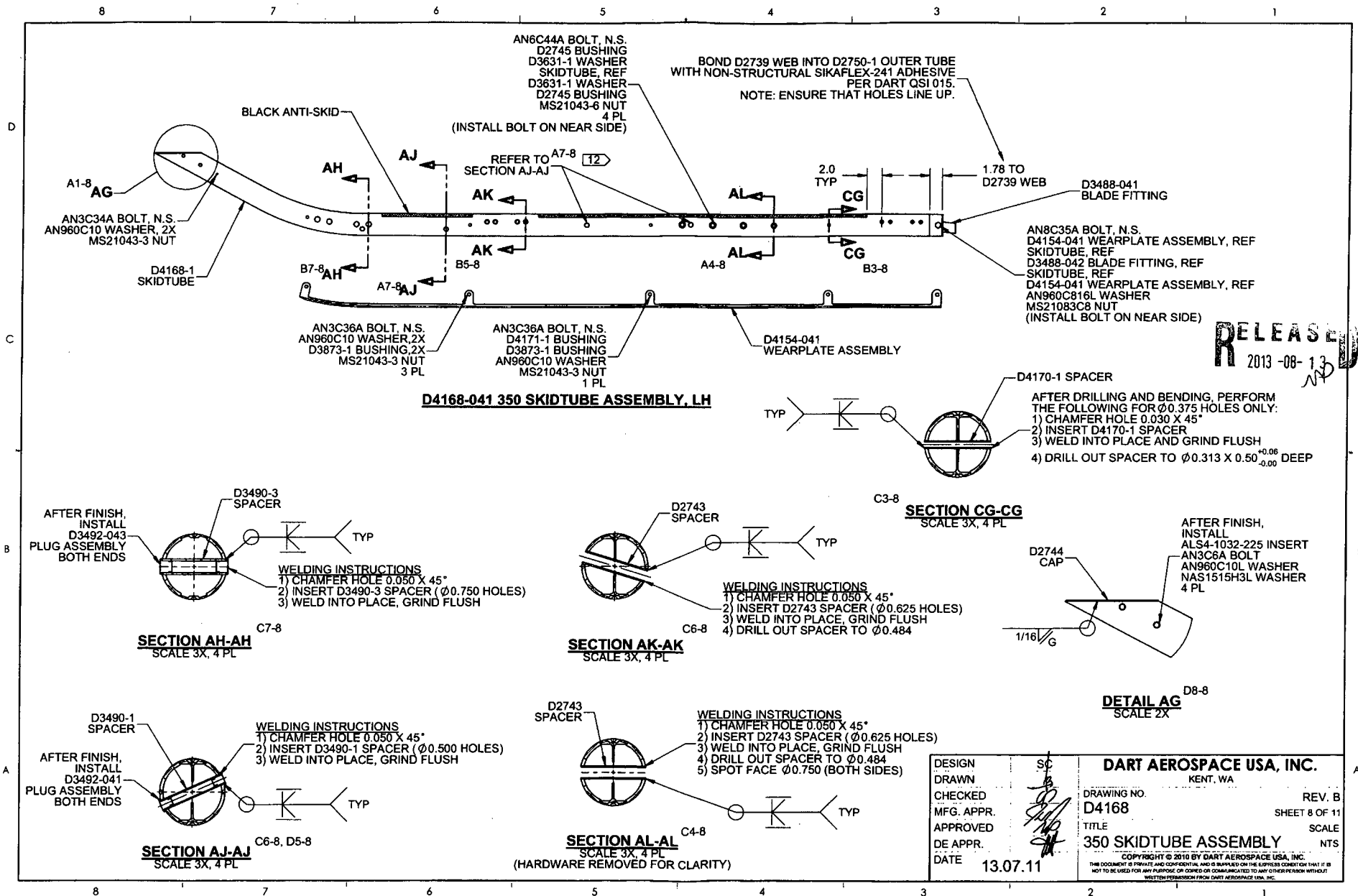


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SCALE 3X, 4 PL

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DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4168 TITLE 350 SKIDTUBE ASSEMBLY REV. B SHEET 7 OF 11 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>
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DATE	13.07.11	

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RELEASED
2013-08-13

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2013-08-13

AN6C44A BOLT, F.S.
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL NUT ON NEAR SIDE)

BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

A1-9
AM
AN3C34A BOLT, F.S.
AN960C10 WASHER, 2X
MS21043-3 NUT

D4168-2
SKIDTUBE

BLACK ANTI-SKID

REFER TO
SECTION AP-AP

A7-9

2.0
TYP

1.78 TO
D2739 WEB

D3488-042
BLADE FITTING

AN8C35A BOLT, F.S.
D4154-041 WEARPLATE ASSEMBLY, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D4154-041 WEARPLATE ASSEMBLY, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON NEAR SIDE)

AN3C36A BOLT, F.S.
AN960C10 WASHER, 2X
D3873-1 BUSHING, 2X
MS21043-3 NUT
3 PL

AN3C36A BOLT, F.S.
D4171-1 BUSHING
D3873-1 BUSHING
AN960C10 WASHER
MS21043-3 NUT
1 PL

D4154-041
WEARPLATE ASSEMBLY

D4168-042 350 SKIDTUBE ASSEMBLY, RH

D4170-1 SPACER

AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1) CHAMFER HOLE 0.030 X 45°
2) INSERT D4170-1 SPACER
3) WELD INTO PLACE AND GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.313 X 0.50^{+0.06}_{-0.00} DEEP

SECTION CH-CH
SCALE 3X, 4 PL

D2744
CAP

AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

DETAIL AM
SCALE 2X

D8-9

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484

SECTION AQ-AQ
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)

SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AP-AP
SCALE 3X, 4 PL

AFTER FINISH,
INSTALL
D3492-043
PLUG ASSEMBLY
BOTH ENDS

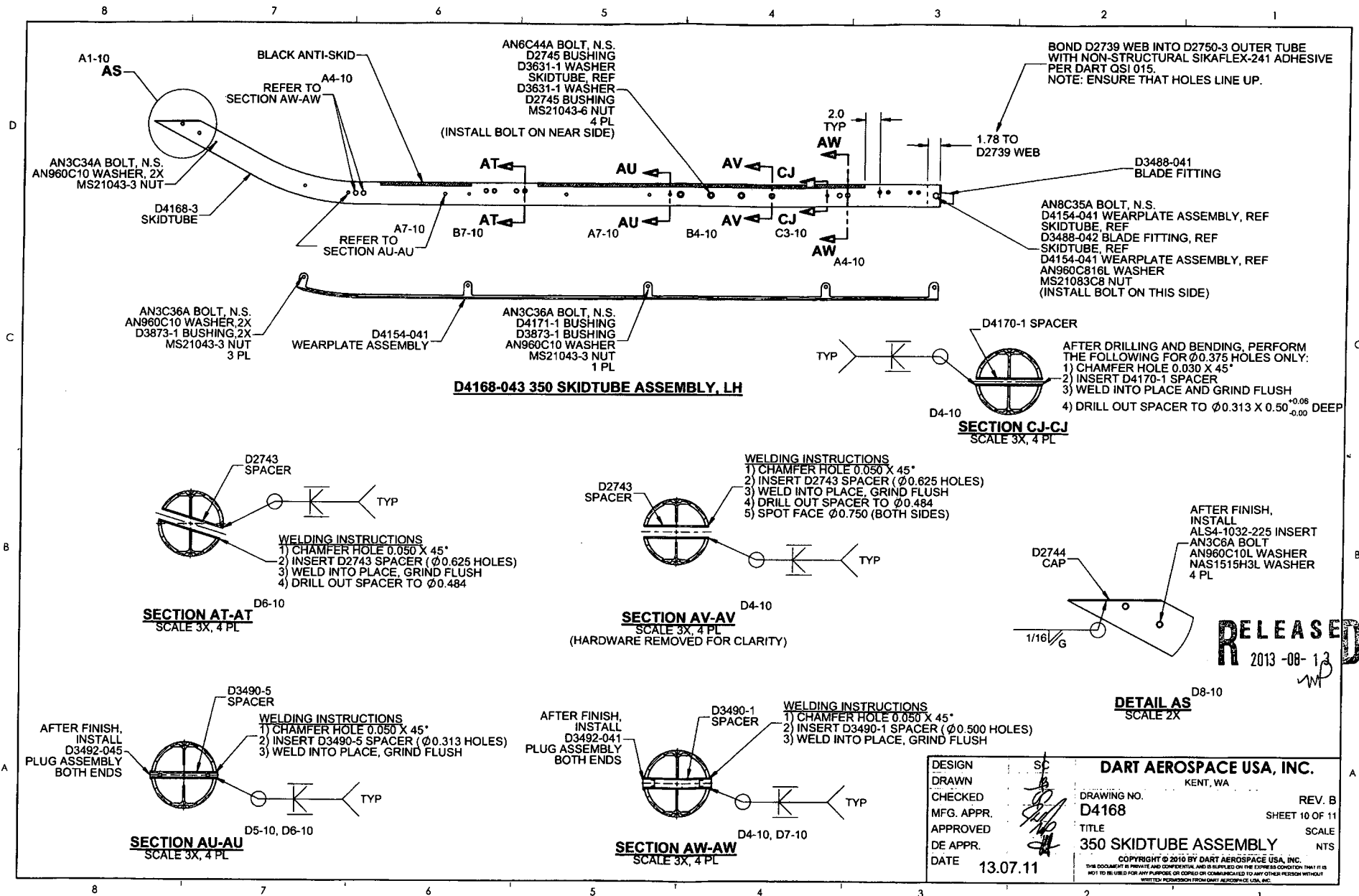
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-3 SPACER (Ø0.750 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AN-AN
SCALE 3X, 4 PL

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS

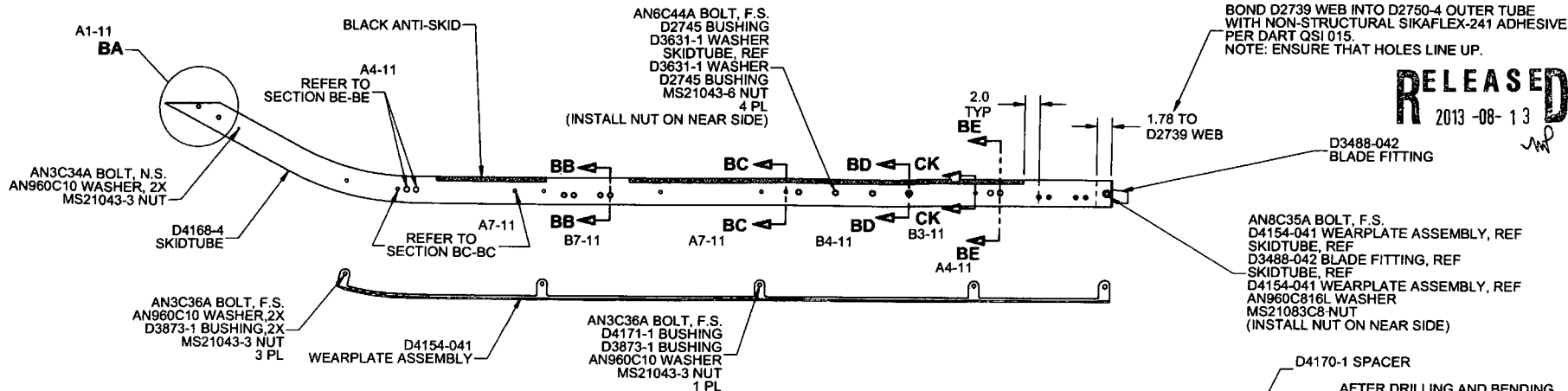
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DART AEROSPACE USA, INC.
KENT, WA
DRAWING NO.
D4168
TITLE
350 SKIDTUBE ASSEMBLY
REV. B
SHEET 9 OF 11
SCALE
NTS
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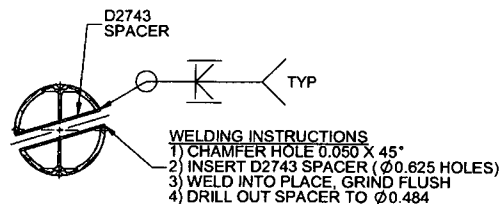


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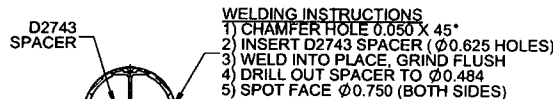
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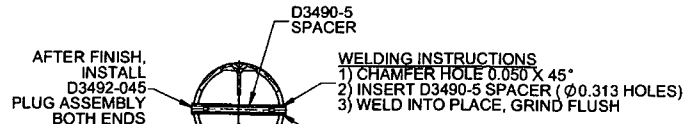
D4168-044 350 SKIDTUBE ASSEMBLY, RH



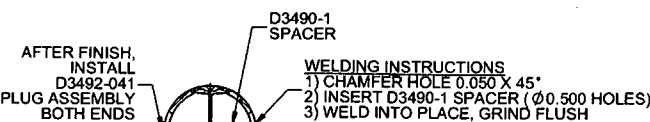
SECTION BB-BB
SCALE 3X, 4 PL



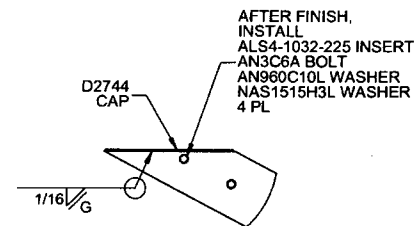
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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CHECKED	JP	DRAWING NO.	REV. B
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